

Work Order ID 144982

April 28, 2016 11:45:11 AM

144982

Page 1

Item ID: D3065-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Leg Assembly *21x*
 Start Date: 5/2/2016 Start Qty: *25* ***25*** Cust Item ID:
 Required Date: 5/6/2016 Req'd Qty: 25.00 ***25*** Customer:
 Reference:

Approvals: Process Plan: *SU* Date: *20160427* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3065	Rev B

100	Small Fab	0.00							
100									
Small Fab	Memo	2.25							
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041								

21x *16/05/03* *9-89*

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.50							
Quality Control									

DAS 30 9-89 *21x* *MAY 03 2016*

120	Identify as per dwg & Stock Location: <i>WA002</i>	0.00							
120									
Packaging	Memo	0.25							
Packaging	LOCATION : WA002								

DAS 30 9-89 *21x* *MAY 03 2016*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	2.50							
Quality Control									

MLJ MAY 04 2016

MLJ MAY 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

April 28, 2016 11:45:16 AM

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144982

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly

Start Date: 5/2/2016

Required Date: 5/6/2016

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 *D3065-1* Step Spacer		Manufactured	No			100	Each	40.0000	1	25		16/05/03	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				40					
				142774				40		21			
D3065-3 *D3065-3* Step Spacer		Manufactured	No			100	Each	21.0000	1	25		16/05/03	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				21					
				142659				21		21			
D3065-5 *D3065-5* Step Leg		Manufactured	No			100	Each	43.0000	2	50		16/05/03	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				43					
				144187				43		31			
D3065-7 *D3065-7* Step Spacer		Manufactured	No			100	Each	40.0000	1	25		16/05/03	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				40					
				142672				40		21			

Picklist Print

April 28, 2016 11:45:16 AM

Page 2

Work Order ID: 144982

144982

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly

Start Date: 5/2/2016

Required Date: 5/6/2016

Start Qty: 25.00

Required Qty: 25.00

MS20470AD4-4

Purchased

No

100

Each

3,720.000

30

750

MS20470AD4-4

Rivet, Universal Head

16/05/03

DAS

36

9-85

Location

Loc Qty

Loc Code

CCK004

2069

M134574

2069

GA

1183

M133922

54

M134294

1129

ST310

468

M132803

468

630



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

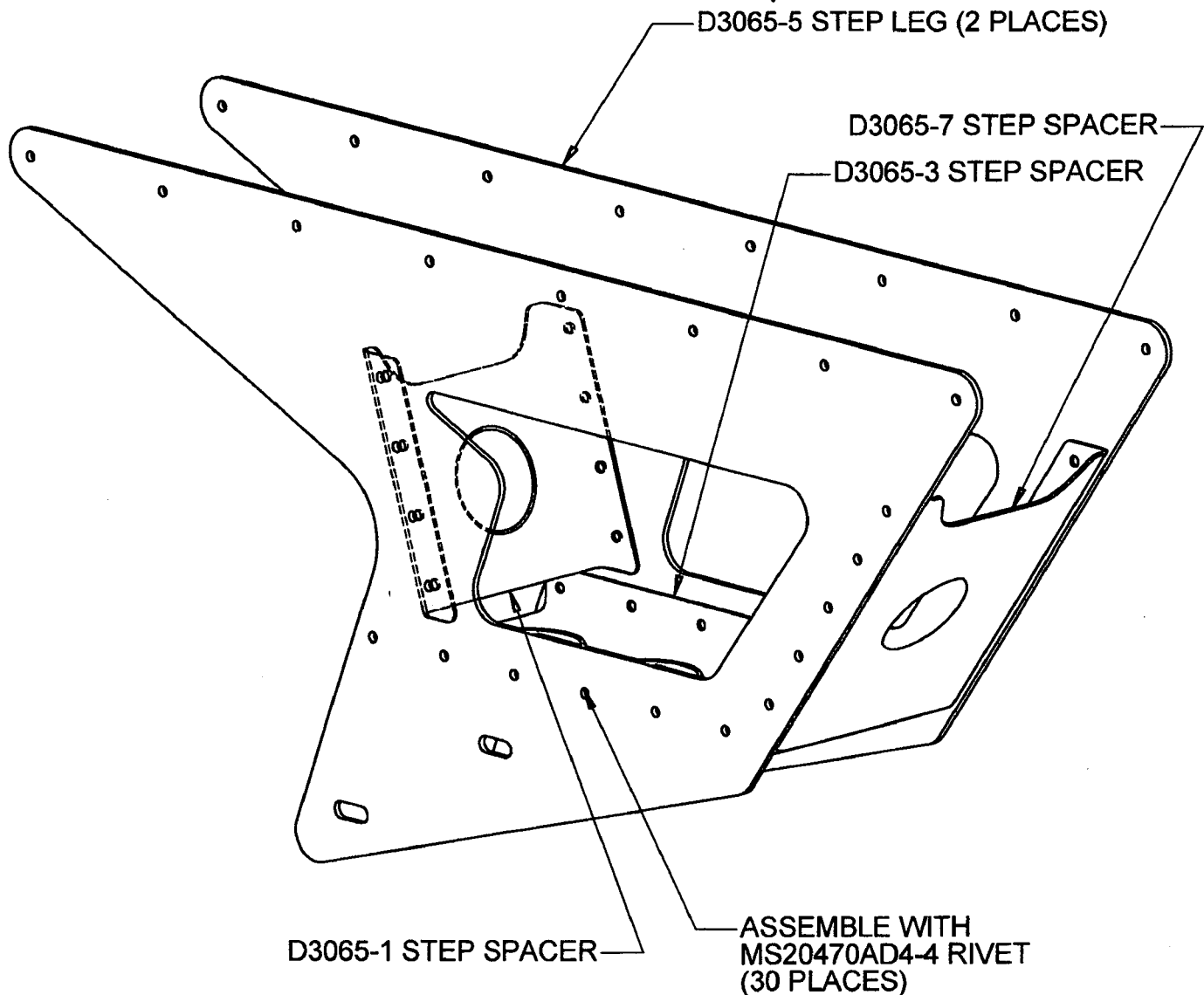
RELEASED

06.06.20 *[Signature]*

20160427

SA

144982



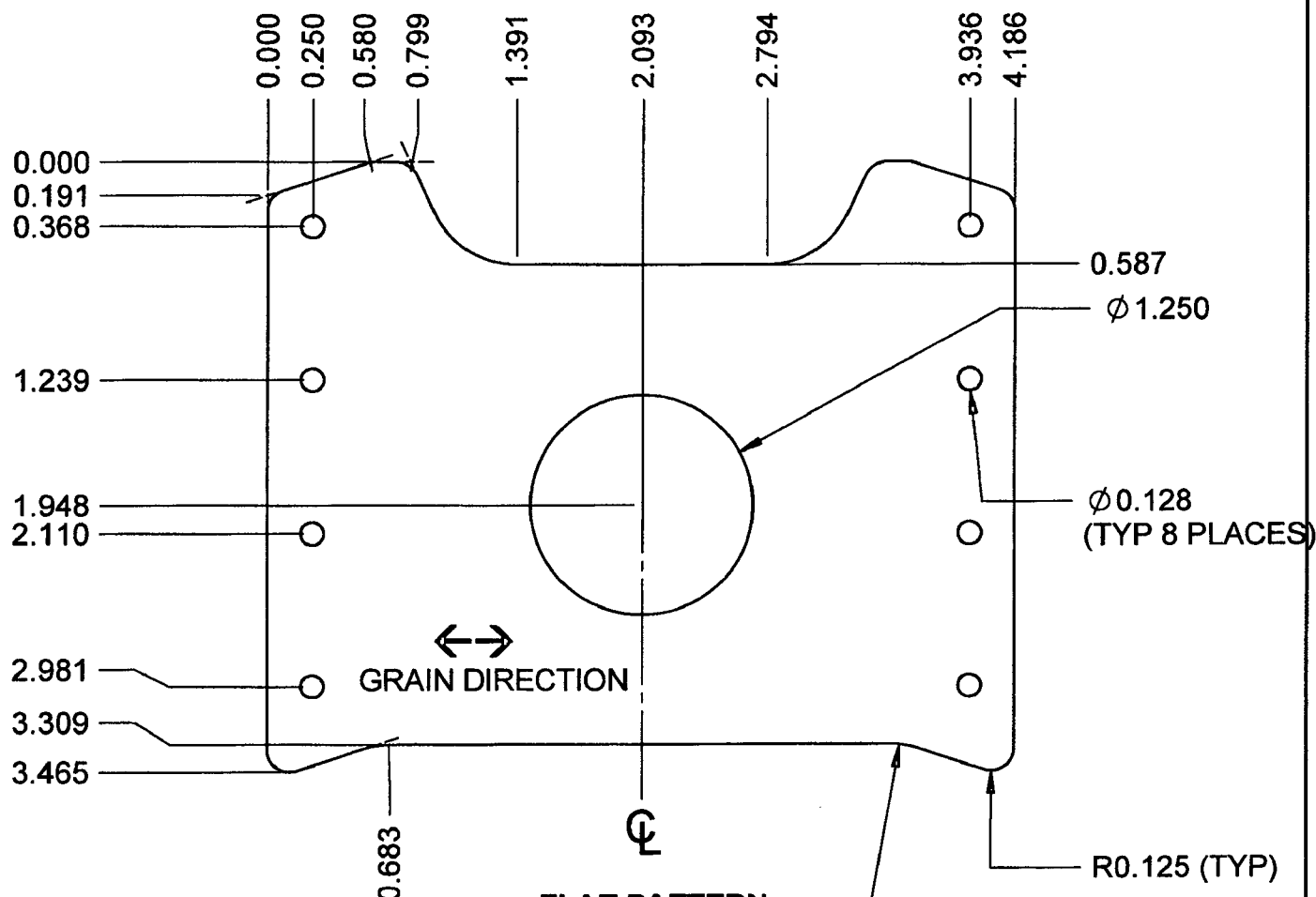
D3065-041 STEP LEG ASSEMBLY

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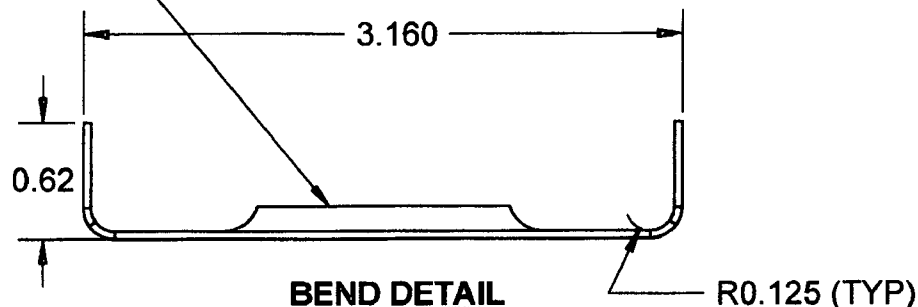
DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER BENDING
TOWARDS SIDE SHOWN
USING DT8174
(2 PLACES)

RELEASED

cl. de-re



D3065-1 STEP SPACER

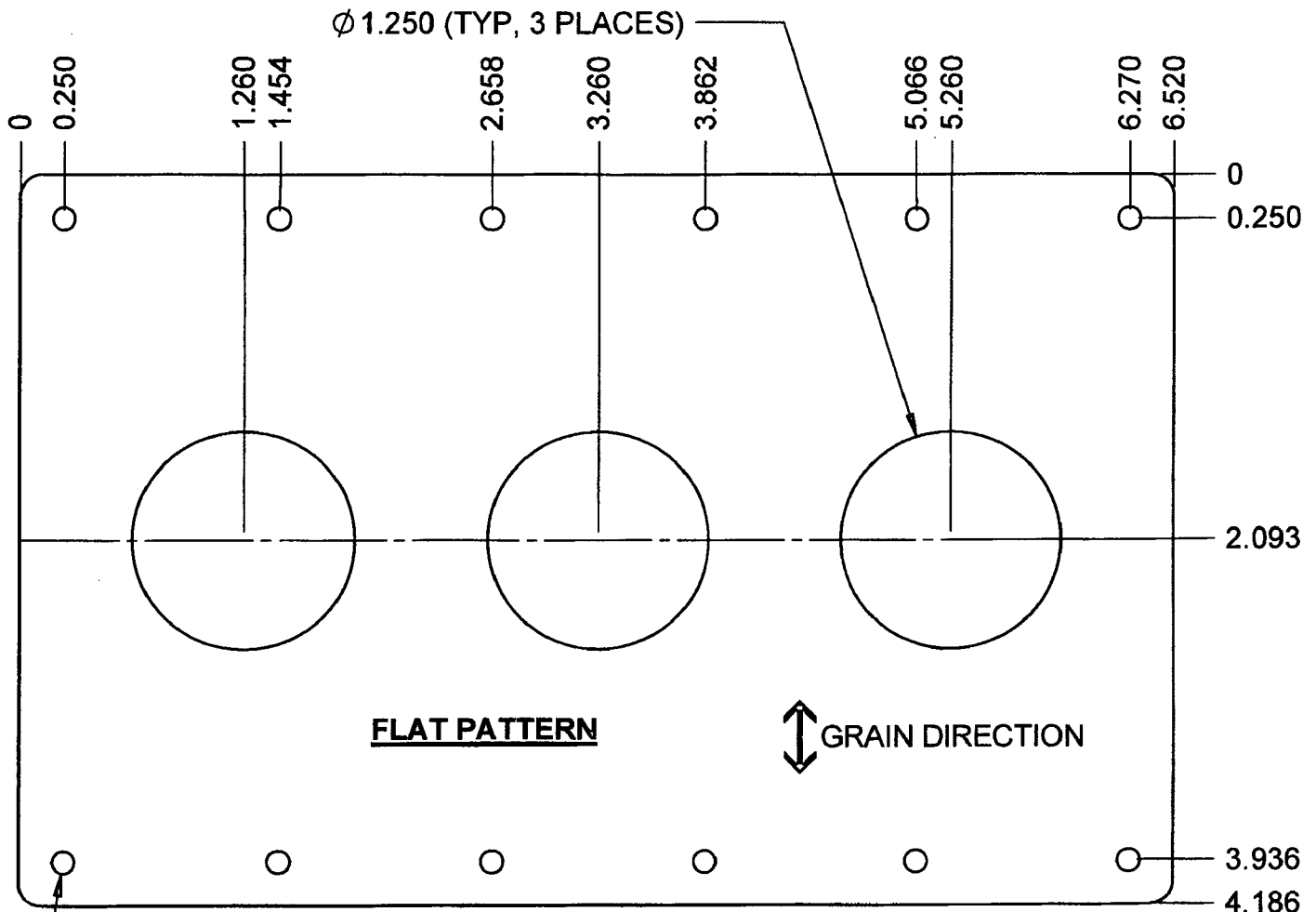
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

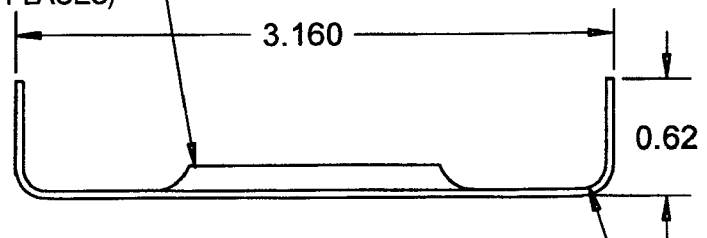


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06 Oct 20 *[Signature]*



BEND DETAIL

D3065-3 STEP SPACER

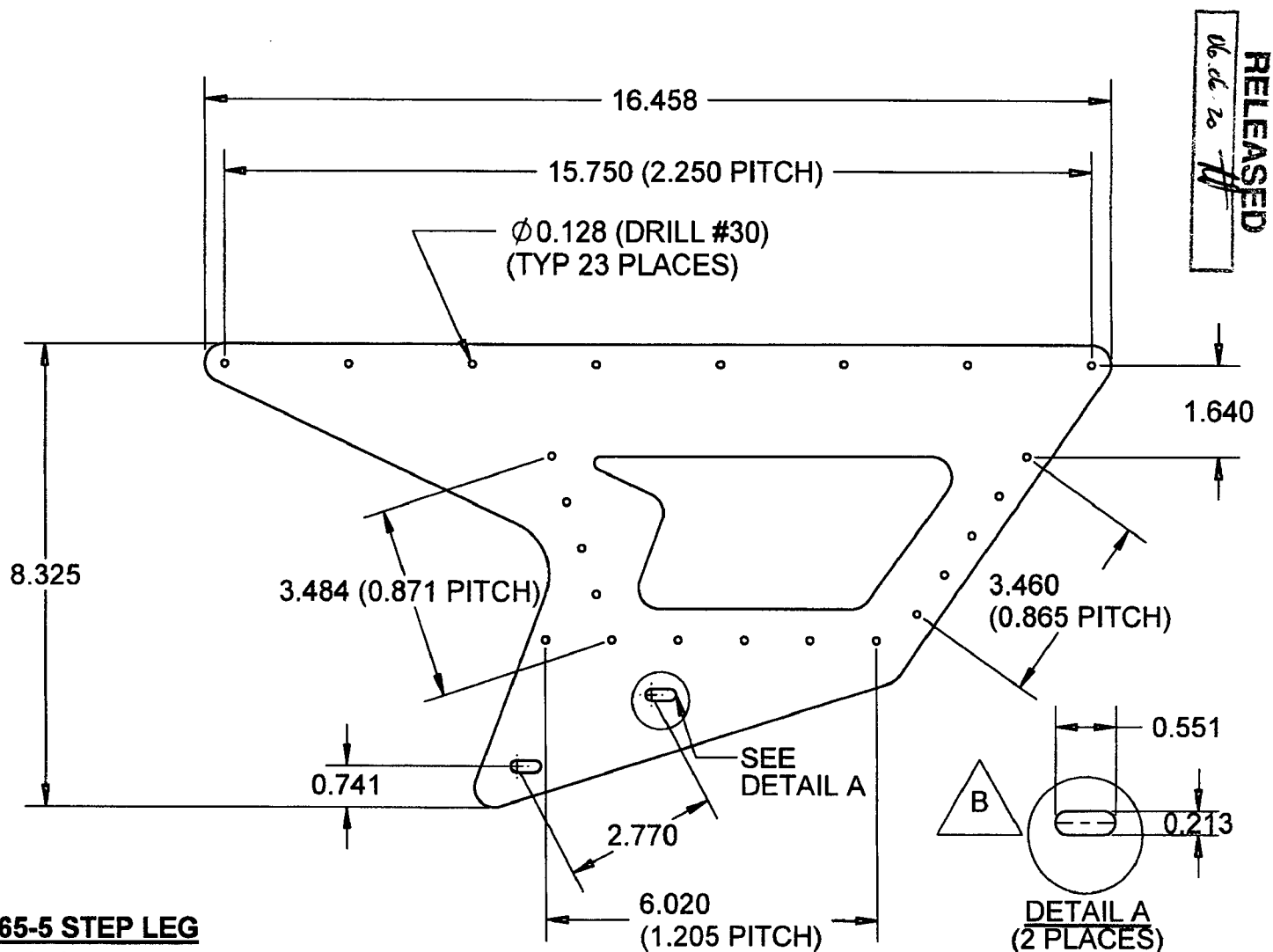
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	40	DRAWN BY	C.B.	DART AEROSPACE LTD
CHECKED	84	APPROVED	84	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	TITLE	D3065	REV. B
			STEP LEG ASSEMBLY	SHEET 4 OF 5
				SCALE 1:3



D3065-5 STEP LEG

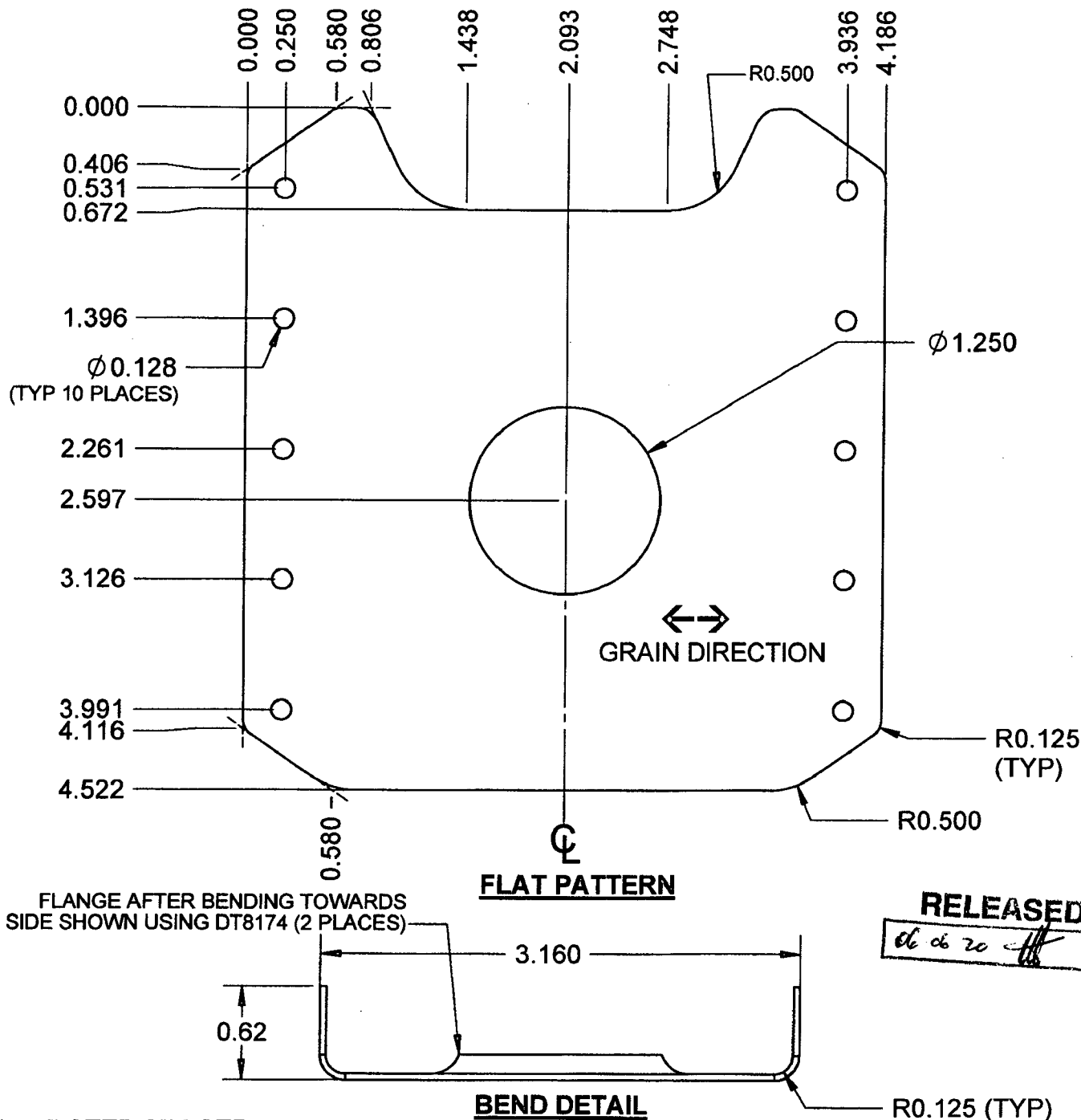
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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